ABSTRACT

When laminating two types of film (1, 2) with different melting points on the two sides of a metal sheet (3), the thickness of the low melting point side film (2) is adjusted. Specifically, the thickness d2 of the low melting point side film (2) at the part sandwiched between the lamination roll (10) and metal sheet (3) is made a range defined by $d2 \geq k(\Delta MP - \Delta T)/V$. Here, ΔMP is the difference of melting points of the two types of film, k is $k \geq 2$, $0 < \Delta T = MP1 - \Phi Ti \leq 50$ (°C) (Ti is the metal sheet temperature at the inlet side of the rolls, V is the sheet running speed, Φ is a constant determined by the heat removal conditions at the time of lamination, where $0.75 \leq \Phi < 1$). Due to this, sticking of the low melting point side film (2) to the lamination roll (10) can be prevented.